



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5445-041
Job Sheet 175969



Part No: D5445-041

Job Qty: 2 ea

Part Name: Longitudinal Beam Assembly, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/13/18

Job Tracking No:

Due Date: 4/20/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C SHEETS 1,4 IPP REV:A NEW ISSUE 16-07-07 JLM VERIFIED BY:DD IPP REV:B 17.01.10 AS PER DWG REV.C DD VERF:JLM IPP REV:C 17.11.15 REVISE AS PER INTUITIVE INSTRUCTION DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	4/19/18	4/19/18	0.00	0.00	Start Up Skid tubes		
100	CNC Bend Skid tubes	2 pcs	4/19/18	4/19/18	0.00	2.00	CNC Bend Skid tube		
110	QC	2 pcs	4/19/18	4/19/18	0.00	0.00	QC2		
120	Mill Conv	2 pcs	4/19/18	4/19/18	0.00	2.00	Mill Conv 1		
130	QC	2 pcs	4/19/18	4/19/18	0.00	0.00	QC2		
140	QC	2 pcs	4/19/18	4/19/18	0.00	0.00	QC8		
150	HandFinish	2 pcs	4/19/18	4/19/18	0.00	1.00	HandFinish1		
160	QC	2 pcs	4/19/18	4/19/18	0.00	0.00	QC7		
170	Small Fab	2 pcs	4/19/18	4/19/18	0.00	1.33	Small Fab		
180	QC	2 pcs	4/19/18	4/19/18	0.00	0.00	QC5		
184	Skid tubes	2 pcs	4/19/18	4/19/18	0.00	1.00	Skid tubes-3		
186	QC	2 pcs	4/19/18	4/19/18	0.00	0.00	QC5		
190	Powdercoat	2 pcs	4/19/18	4/19/18	0.00	0.40	Powdercoat1		
200	QC	2 pcs	4/19/18	4/19/18	0.00	0.00	QC3		
210	HandFinish	2 pcs	4/20/18	4/20/18	0.00	1.00	HandFinish4		
220	QC	2 pcs	4/20/18	4/20/18	0.00	0.00	QC5		
230	Packaging	2 pcs	4/20/18	4/20/18	0.00	0.00			
240	QC21-SA	2 Ea	4/20/18	4/20/18	0.00	0.00	QC21		

Part Op 100 - BEND/CUT AS PER DWG

Descriptions: 120 - -MILL/DRILL/C/SINK AS PER DWG. -Insure proper orientation -DEBURR

170 - INSTALL NUT PLATES AS PER DWG

184 - 1- Pick (4) D4720-1 space for each beams and chemical convert them. 2- Swage x-bolt spacers as per dwg. Trim off excess material as required. 3- After swaging, ream x-spacer hole if necessary to finish size. 4- Touch up alodine after swaging. 5-INSTALL END CAPS

190 - MASK NUT PLATE HOLES*** START TIME: 2:20 OVEN TEMPERATURE: 300 FINISH TIME:

2:50

210 - SEAL END CAPS WITH SIKAFLEX AS PER NOTE 11

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6TR1.5X1.0W125	6061-T6 Rect Tube 1.5 X 1.0 X .125W	12 ft (6 ea)	90-Start up Operation	
CR2672-3-(03)	Cherry Rivet	16 Ea (8 ea)	170-Small Fab	5057521
MS21059-4	Nut Plate	6 Ea (3 ea)	170-Small Fab	5065256



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Container No: S064274



Part: D5445-041

Job No: 175969

Serial No/Batch: S064274

Revision: C

Inspector:

Date: 04/24/18

MS21061L4
D4720-1
D5445-043
MS24694-S3

Nutplate
Spacer
End Cap Assembly
Screw

2 Ea (1 ea) 170-Small Fab
8 Ea (4 ea) 184-Skidtubes
4 Ea (2 ea) 184-Skidtubes
8 Ea (4 ea) 184-Skidtubes

505257
5030687
F158775
m136643

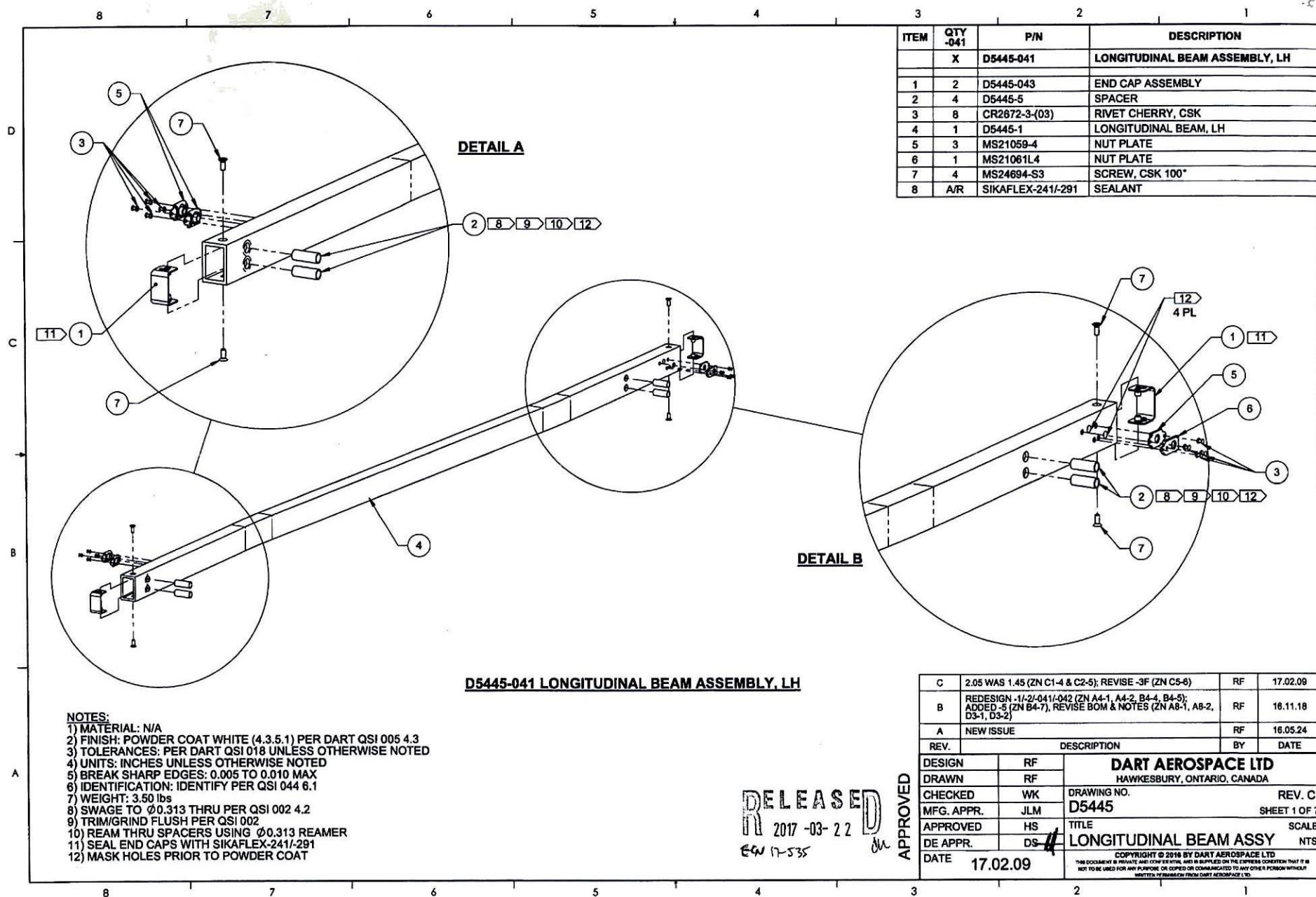
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6TR1.5X1.0W125	12	48	0
170-Small Fab	CR2672-3-(03)	16	111	0
	MS21059-4	6	8	0
	MS21061L4	2	4	0
184-Skidtubes	D4720-1	8	402	0
	D5445-043	4	30	0
	MS24694-S3	8	59	0

Part Specifications

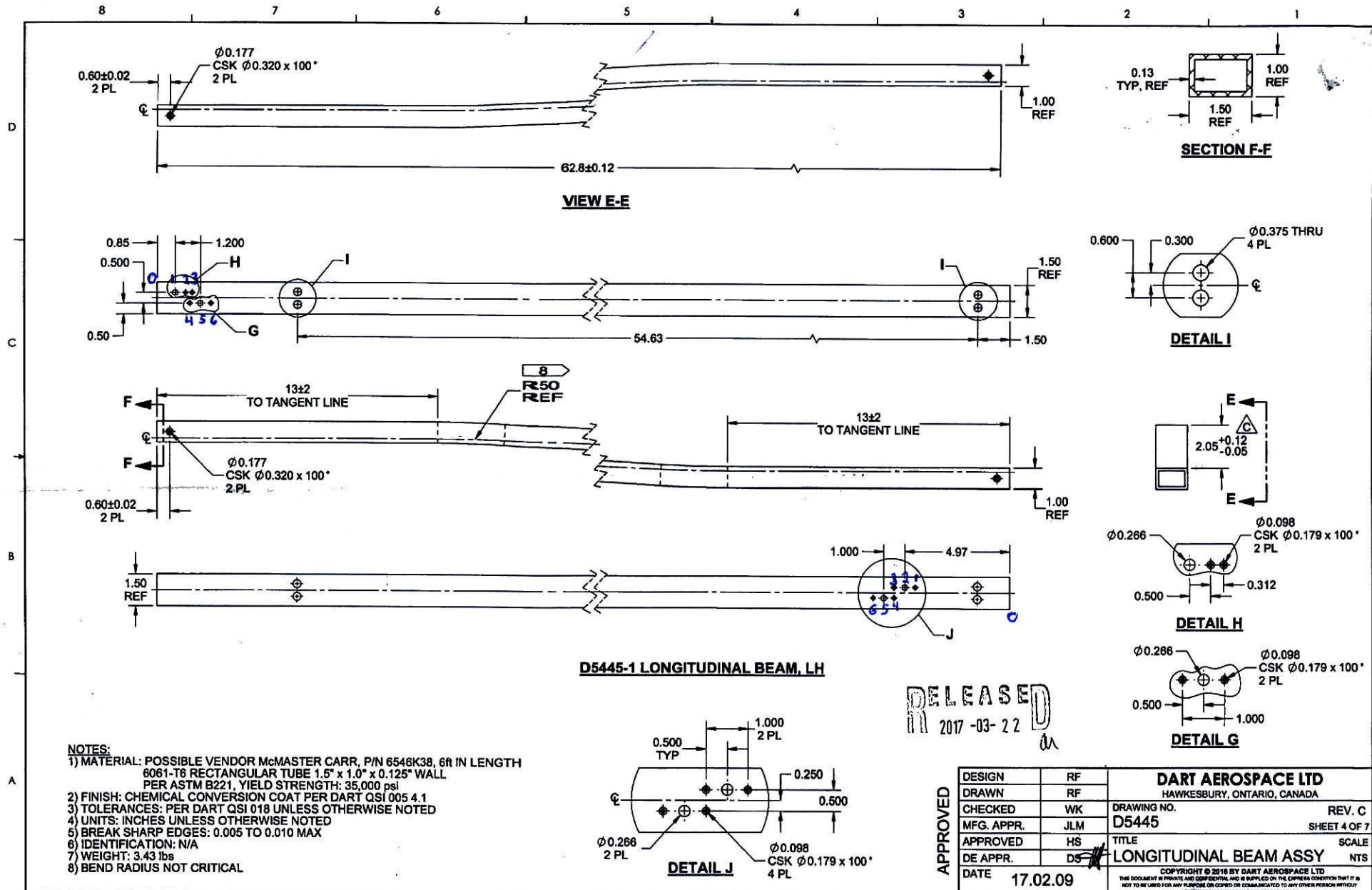
Specifications could not be found.

Plex 4/13/18 7:10 AM Dart.lajeunesse.marie



Y 0.177
 X 1-0.850
 2-1.350
 3-1.662
 X 4-1.550
 5-2.050
 6-2.550

W 0.177



(J)

Y-0.998
 X 4-4.470
 2-4.970
 3-5.470

Y-0.498
 X 5-4.470
 5-5.970
 6-6.470

DART AEROSPACE LTD	Work Order: 175969
Description: Longitudinal Beam assy - LH	Part Number: 05445-1
Inspection Dwg: Same as P/U Rev: C	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
62.8"	± 0.12"	62.80	✓		Tape	
1.00 Ref	± 0.030	0.997	✓		Vernier CLK-19	
1.50 "	± "	1.496	✓		"	
0.13 "	"	0.118"	✓		"	
all 0.60 2 places	± 0.030	0.600	✓		"	
all 0.177	± 0.002/-0.001	0.178	✓		"	
all CSK 0.320 x 100°	"	0.320	✓		" & C Sink 100°	
0.85	± 0.030	0.850	✓		Vernier CLK-19	
1.200	± 0.010	1.200	✓		"	
0.500	"	0.500	✓		"	
0.50	± 0.030	0.500	✓		"	
54.63	± "	54.625	✓		Tape	
1.50	"	1.500	✓		Vernier CLK-19	
0.600	± 0.010	0.600	✓		"	
0.300	"	0.300	✓		"	
0.375	± 0.006/-0.001	0.378	✓		"	
1.000	± 0.010	1.000	✓		"	
4.970	± 0.030	4.970	✓		"	
2.05	+0.12 / -0.05	2.175	✓		"	
0.266	+0.006 / -0.001	0.267	✓		"	
0.500	± 0.010	0.500	✓		"	
0.312	"	0.312	✓		"	
all 0.098	± 0.005/-0.001	0.099	✓		"	
all 0.179 x 100°	± "	0.180	✓		Vernier CLK-19 & C Sink	
all 0.500	± 0.010	0.500	✓		Vernier CLK-19	
all 1.000	"	1.000	✓		"	
0.250	"	0.250	✓		"	
0.500	"	0.500	✓		"	

DAS
54
9-89

Measured by: [Signature]	Checked by: [Signature]	QC Inspector:
Date: 18/5/14	Date: 18/05/15	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	